

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015674**Date Inspected:** 16-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face B
- 2). OBG Field Splice 3W/4W Weld ID: C1 and C2, Face B
- 3). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B
- 4). OBG Field Splice 4E/5E Weld ID: D1 & D2 Face B

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face B

. The QAI observed SE QC Inspector Jesse Cayabyab performing Magnetic Particle Testing (MT) of OBG Field Splice 1W/2W Weld ID: D1 & D2, Face B. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 3W/4W Weld ID: C1 and C2, Face B

The QAI performed verification Ultrasonic Testing of 10% of the OBG Field Splice 3W/4W Weld ID: C1 and C2 from the B Face. The testing was performed in accordance with AWS D1.5 Section 6 Part C and evaluated per Table 6.3 UT Acceptance-Rejection Criteria-Tensile Stress.

The QAI tested 550mm of each weld C1 and weld C2 and observed that the areas tested appeared to be in general compliance with contract documents.

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3). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B

The QAI performed verification Ultrasonic Testing of 10% of the OBG Field Splice 3E/4E Weld ID: D1 and D2 from the B Face. The testing was performed in accordance with AWS D1.5 Section 6 Part C and evaluated per Table 6.3 UT Acceptance-Rejection Criteria-Tensile Stress.

The QAI tested 425mm of each weld D1 and weld D2 and observed that the area tested of weld D1 appeared to be in general compliance with contract documents. The QAI observed that the area of weld tested of weld D2 did not appear to be in general compliance with contract documents and one (1) Class A Reject was observed and recorded. See the TL-6027 Ultrasonic Testing Report generated by the QAI on this date.

4). OBG Field Splice 4E/5E Weld ID: D1 & D2 Face B

The QAI performed verification Ultrasonic Testing of 10% of the OBG Field Splice 4E/5E Weld ID: D1 and D2 from the B Face. The testing was performed in accordance with AWS D1.5 Section 6 Part C and evaluated per Table 6.3 UT Acceptance-Rejection Criteria-Tensile Stress. The QAI tested 425mm of each weld D1 and weld D2 and observed that the areas tested appeared to be in general compliance with contract documents.

Summary of Conversations:

The QAI spoke with SE QC Inspector Jesse Cayabyab (the QC inspector responsible for the QC UT of OBG Field Splice 3E/4E Weld ID: D2) and informed him of the results of the QAI verification testing.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
